

Work Order ID 150532

Thursday, August 25, 2016 10:37:53 AM

150532

Page 1

Item ID: D5208-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Blanking Plate
Start Date: 8/29/2016 Start Qty: ~~12.00~~ **24** ***12*** Cust Item ID:
Required Date: 9/19/2016 Req'd Qty: ~~12.00~~ **24** ***12*** Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: **AUG 25 2016** Pooling: Date: Run Start ***NR1***
QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5208	B								PR 2016/09/03
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.20							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.02							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.04							
Quality Control									

**DAS
38
9-89**

SEP 06 2016

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Thursday, August 25, 2016 10:37:53 AM

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Page 2

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Item Name: Blanking Plate
Start Date: 8/29/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 9/19/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
130									
Packaging	Memo	0.02							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

DAS 21 9-89 SEP 06 2016

DAS 21 9-89 SEP 07 2016

Picklist Print

Thursday, August 25, 2016 10:37:56 AM

Page 1

Work Order ID: 150532

150532

Parent Item: D5208-1

D5208-1

Parent Item Name: Blanking Plate

Start Date: 8/29/2016

Required Date: 9/19/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 15.01.29 NEW ISSUE DD VERF:JLM IPP
REV:B 15.05.28 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S24GA		Purchased	No				sf	77.7490		1.389474			

M304S24GA

304/316 .025 Sheet

PR 2016/09/03

Location

Loc Qty

Loc Code

MAT020

64

m135275

64

MAT20

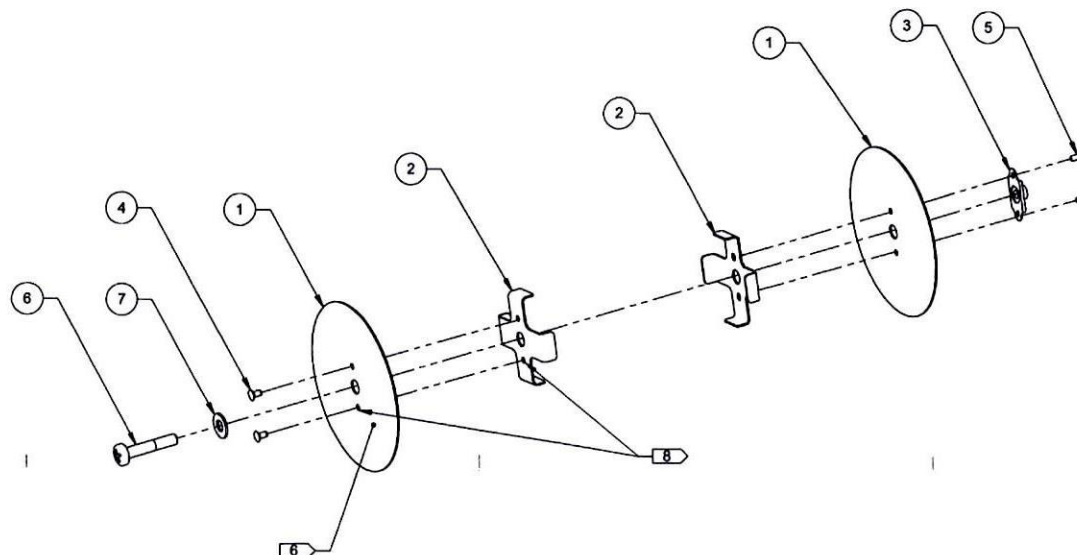
13.749

m134677

13.749

u.8

ITEM	QTY	P/N	DESCRIPTION
	X	D5208-041	BLANKING PLATE ASSY
1	2	D5208-1	BLANKING PLATE
2	2	D5208-3	GUIDE
3	1	FM5001-050	ANCHOR NUT, FLOATING
4	2	MS20427M3-3	RIVET, SOLID, CSK
5	2	MS20615-3M3	RIVET, SOLID, PAN-HEAD
6	1	LN9038-05-26	SCREW, PAN-HEAD
7	1	BS4320-A5	WASHER (ALT: BS4320-A-5, BS4320-AM5, NAS1149C0332R)



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150532 MJS
160805

RELEASED

A7. 2015 JUN 22 EN 5-589

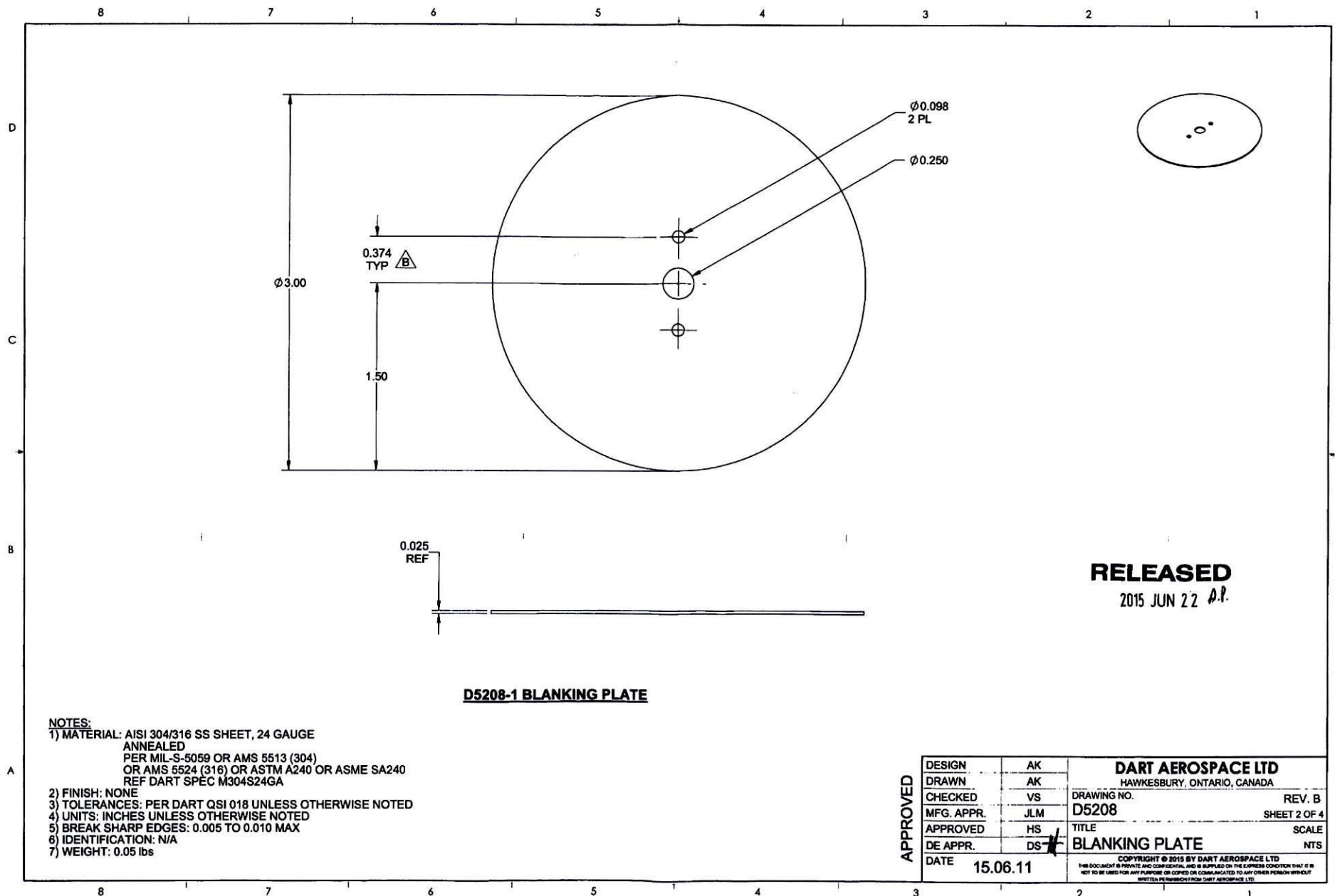
D5208-041 BLANKING PLATE ASSY

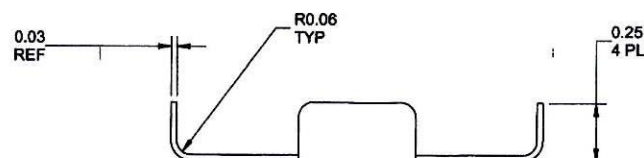
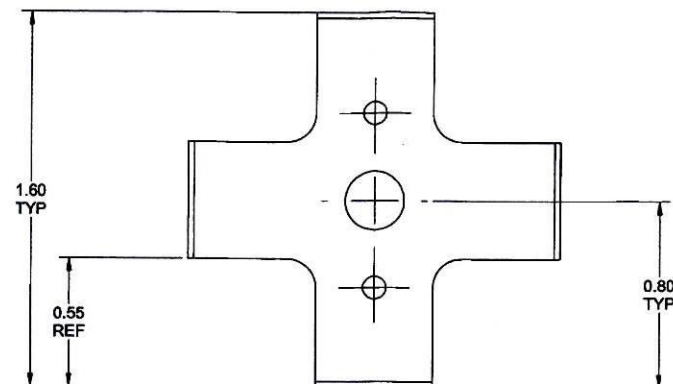
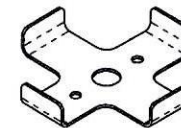
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) DIMPLE THIS FACE OF D5208-1/3 PRIOR TO INSTALLING RIVETS

B	UPDATED HOLE LOCATION, 0.374 WAS 0.344 (ZN C8-2, ZN C2-4). ADDED ALTERNATIVE PART NUMBERS.	AK	15.06.11
A	NEW ISSUE	AK	15.01.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5208	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BLANKING PLATE	NTS
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APPROVED





D5208-3 GUIDE

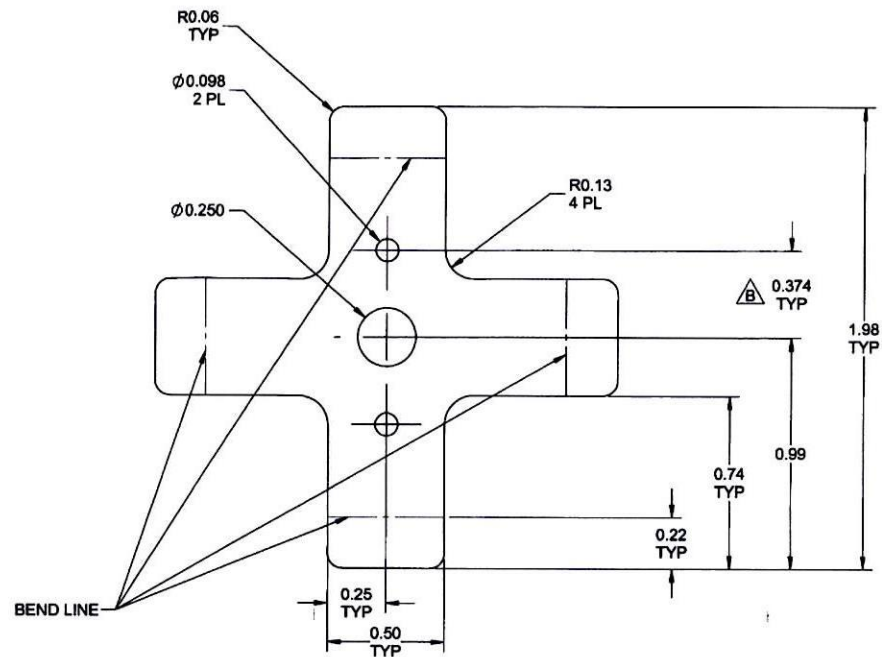
RELEASED
2015 JUN 22 48

NOTES:

- 1) MATERIAL: MAKE FROM D5208-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5208	SHEET 3 OF 4
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D5208-3F FLAT PATTERN

RELEASED
2015 JUN 22 A.P.

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 24 GAUGE
ANNEALED
PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

APPROVED	DESIGN	AK	DART AEROSPACE LTD	
	DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D5208	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BLANKING PLATE	NTS
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